DART AEROSPACE LTD	Work Order:	21612
Description: Return 422	Part Number:	D2668-1/D2667-1
Dwg:	Qty:	7
		Page of

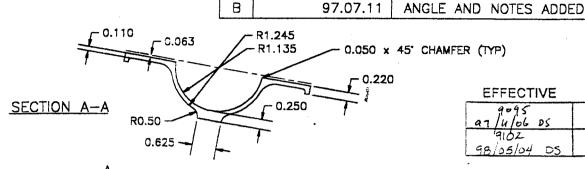
Step	Location	Procedure			T 01	٦
1	De	Issue Iraveler	Ву	Date	Qty	\dashv
					-	-
ţ	QCS/3	Inspect sachcles 02668-1 37350	4	05.10.19	1	
		and D2667-1 B7348 for clamage.				
2	FP.	clean saddle holes without	M	05 10 26)	
		powder cont without changing hole				
3	20	dimensions as per Duy's, and alodine holes.				1
_2	tb	re-purely cont as per RS 1004,	M	05 10 27	<i>J</i>	
- دا		Inspect Powder cost.	14			
5	_	wrap in form, and identify with	La	05/10/27	<i>1</i>	
		original batch numbers due to				
	i	original hatch is engraved into				
		the saddles, and stock	91	05/11/20)	C O
6	AC	0001 700	7,7	05-10-28	· ·	
*7	05/0021	Close w10.				
				05/10/28	1	
			-			
				·		

Rev	Date	Change	Revised By	Approved

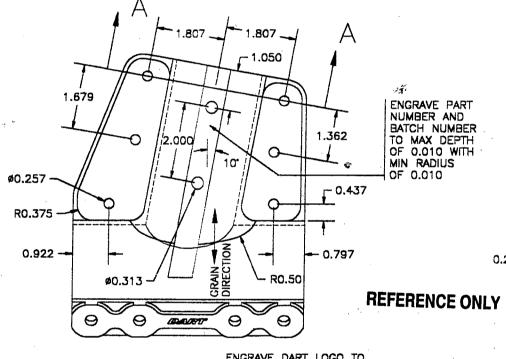
		. And	-
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			N.
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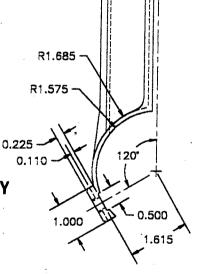


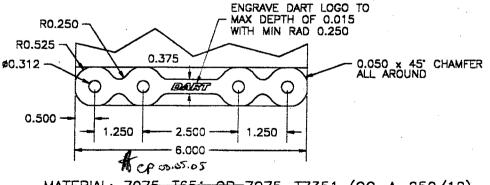
DESIG	mey	DRAWN BY	DART AEROSPACE USA, INC.		
CHEC	KED MAN	APPROVED	DRAWING NO. D2667	REV. B	
DATE	V I W	14	TILE	SHEET 1 OF 1	
97.0	7.11		SADDLE AFT OUTSIDE HIGH	2:5	
Α		97.03.25	NEW ISSUE		



EFFECTIVE	DEOs
9095 97/4/06 DS	98112/14
9102 98/05/04 DS	







CONTROLLED COPY

MATERIAL: 7075-T651 OR 7075-T7351 (QQ-A-250/12)

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2

NOTE: D2667-1 SHOWN (D2667-2 is OPPOSITE)

BREAK ALL SHARP EDGES 0.010 TO 0.020 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN DRAWN BY DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA DRAWING NO. REV. B CHECKED D2668 SHEET 1 OF 1 TITLE SCALE DATE SADDLE AFT INSIDE HIGH 97.07.11 2:5 97.03.25 NEW ISSUE Α 97.07.11 ANGLE AND NOTES ADDED В

R1.245

R1.135

1.808

12.00d

0

0.250

1.679

0

CONTROLLED COP

R0.375 (TYP)

r 0.438

ø0.257

0.922

 EFFECTIVE
 DEOs

 9095
 9122

 97 | u | ob
 PS
 78/12/14

 9102
 0.050

 98/05/04
 DS

0.050 x 45' CHAMFER (TYP)-0.063 0.110 0.063 SECTION A-A

R0.50

1\$362

0.797

0

0.625

1.808

R1.575 REFERENCE ONLY

1.000 ENGRAVE
NUMBER
BATCH N
TO MAX
OF 0.01
0.500 0.110 MIN RAD

ENGRAVE PART NUMBER AND BATCH NUMBER TO MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010

WITH 0F R0.500 R0.525 P0.312 0.500 1.250 1.250

6.000

RELEASE)

97/07/16 DS

GO. 55.05

1.615

MATERIAL: -7075 T651 OR 7075-T7351 (QQ-A-250/12)

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2

NOTE: D2668-1 SHOWN (D2668-2 IS OPPOSITE)
BREAK ALL SHARP EDGES 0.010 TO 0.020

0.050 × 45° CHAMFER ALL AROUND

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED